

ABSTRACT

A. cutting tool for metal cutting operations employing detachable cutting insert secured to cartridges. The cartridges have a clamping portion that is resiliently transformable between a normally non-expanded state and a biased expanded state by means of a clamping screw received in
5 a through bore in the cartridge. The clamping portion is slidably insertable into the cartridge pocket when in the normally non-expanded state, and is securely retained in the cartridge pocket when in the biased expanded state.